

Date: Monday, 11/05/2009 1:20:53 PM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: FRAME		
Job Number	: 47843			Part Number	: D22527		
Estimate Number	: 13820			Drawing Number	: D2252 REV G		
P.O. Number	:			Project Number	: N/A		
This Issue	: 11/05/2009 S.O. No. :			Drawing Revision	: G		
Prsht Rev.	: NC			Material	:		
First Issue	: / / Type : LARGE FAB ASSY			Due Date	: 22/05/2009 Qty: 4 Um: Each		
Previous Run	: 46829						
Written By	:						
Checked & Approved By	: <u>JUL 09.05.11</u>						
Comment	: Est Rev:A 09.03.18 New Issue EC verified by:DD						

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube .75x.75x.065W	
		Comment: Qty.: 2.1000 f(s)/Unit Total : 8.4000 f(s) 304 SQ Tube .75x.75x.065W batch: <u>M111432</u>	<u>SAD 09-05-20</u>
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	
		Comment: LARGE FABRICATION RESOURCE 1  1- Cut as per dwg D2252 2- Deburr and remove identification markings on tube	
3.0	QC5	INSPECT WORK TO CURRENT STEP	
		Comment: INSPECT WORK TO CURRENT STEP	<u>SAD 09-05-20 (4)</u>
4.0	PACKAGING 1	PACKAGING RESOURCE #1	
		Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>WA</u>	<u>SAD 09-05-20 (4)</u>
5.0	QC21	FINAL INSPECTION/W/O RELEASE	
		Comment: FINAL INSPECTION/W/O RELEASE	<u>09/05/20 (4)</u>
		Job Completion	
			<u>MF 09-05-22</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

ITEM	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
1	X		D2252-041	BASKET ASSEMBLY
3		X	D2252-043	LID ASSEMBLY
7	2	2	D2221-1	RIB
8	5		D2235-1	RIB
9	2	2	D2252-1	FRAME
10		2	D2252-7	FRAME
11	1		D2252-9	FRAME
12	1		D2252-11	FRAME
13	1		D2252-13	FRAME
14	1		D2252-15	FRAME
15	4		D2252-17	FRAME
16		1	D2252-23	FRAME
17	2		D2253-1	LUG
18	2		D2254	GUSSET
19	1	1	D2327-3	BUSHING
20		1	D2329	LABEL PLATE
21	4	2	D2581	MOUNTING CHANNEL
22		2	D2989-19	RIB
23	3		D3748-1	HINGE HALF
24		3	D3749-1	HINGE HALF

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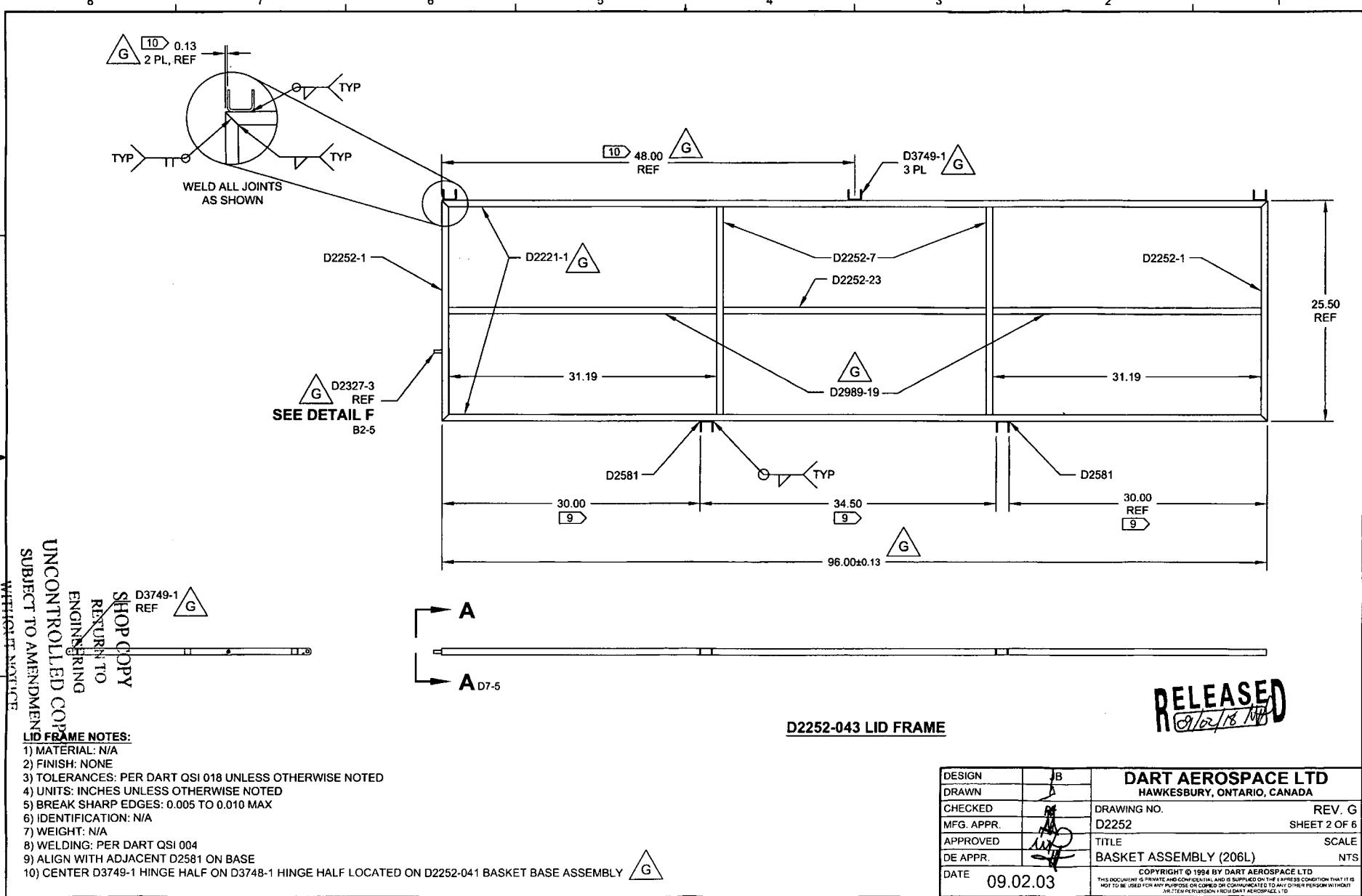
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NOTES:  
 1) FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING  
 REF. DART SPEC M304TS0.750W.065  
 2) MESH MATERIAL: 3/4-16F EXPANDED SS  
 REF DART SPEC M304EX0.75-16F  
 3) FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3  
 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 5) UNITS: INCHES UNLESS OTHERWISE NOTED  
 6) BREAK SHARP EDGES: N/A  
 7) IDENTIFICATION: N/A  
 8) WEIGHT: N/A  
 9) WELDING: PER DART QSI 004

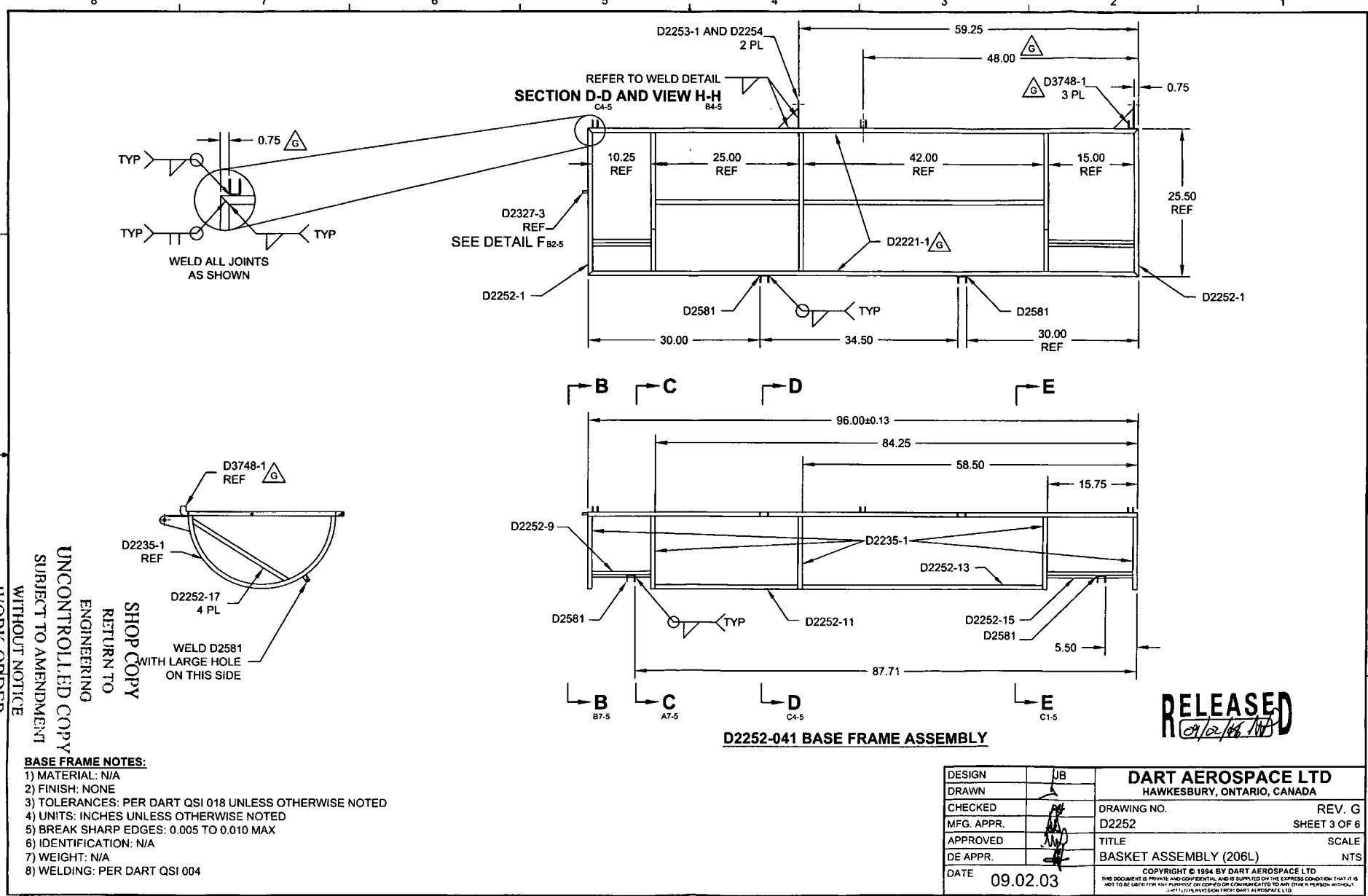
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G	ADDED 'ITEM' COLUMN TO PARTS LIST; ADDED NOTE 10 ON SHT 2; ITEMS 23 AND 24 REPLACE D2232-1/3; STRETCHED LID FROM 95.27" TO 96.00"; ITEM 7 REPLACES D2252-3/19; ITEM 19 (ON LID) REPLACES D2327-1; ITEM 22 REPLACES D2252-21; UPDATED TOOLING (ZN A6-5). PIN REASON: SEE PAR#09-006.	MB	09.02.03
F	DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. SHT 2 VIEWS INVERTED FOR CLARITY. FRAME MATERIAL THICKNESS WAS 0.060.	AJS	08.08.11
E	INCORPORATED D1 & D2. ADDED D2231-1/3 & D2252-19.	MB	05.11.10
D	MODIFIED LATCH, D2581 WAS D2255-3	BK	99.09.14
C	RE-DRAWN	BK	95.12.11
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. G
MFG. APPR.		D2252	SHEET 1 OF 6
APPROVED		TITLE	SCALE
DE APPR.		BASKET ASSEMBLY (206L) NTS	
DATE	09.02.03	COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS THE PROPERTY OF DART AEROSPACE LTD. IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN CONSENT OF DART AEROSPACE LTD.	



DESIGN	B	DART AEROSPACE LTD
DRAWN	<i>JB</i>	HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>BB</i>	DRAWING NO. REV. G
MFG. APPR.	<i>AA</i>	D2252 SHEET 2 OF 6
APPROVED	<i>MM</i>	TITLE SCALE
DE APPR.	<i>MM</i>	BASKET ASSEMBLY (206L) NTS
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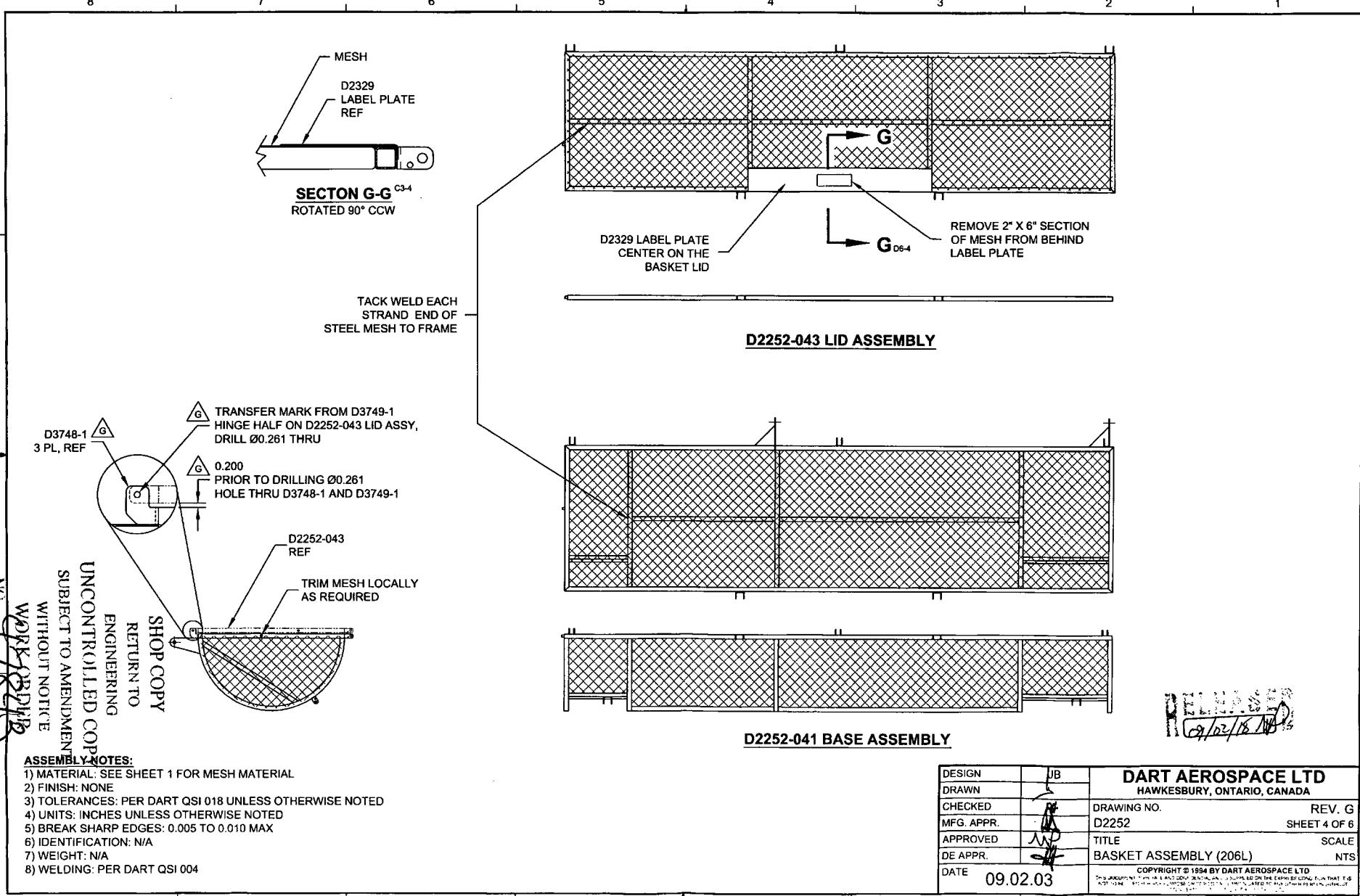
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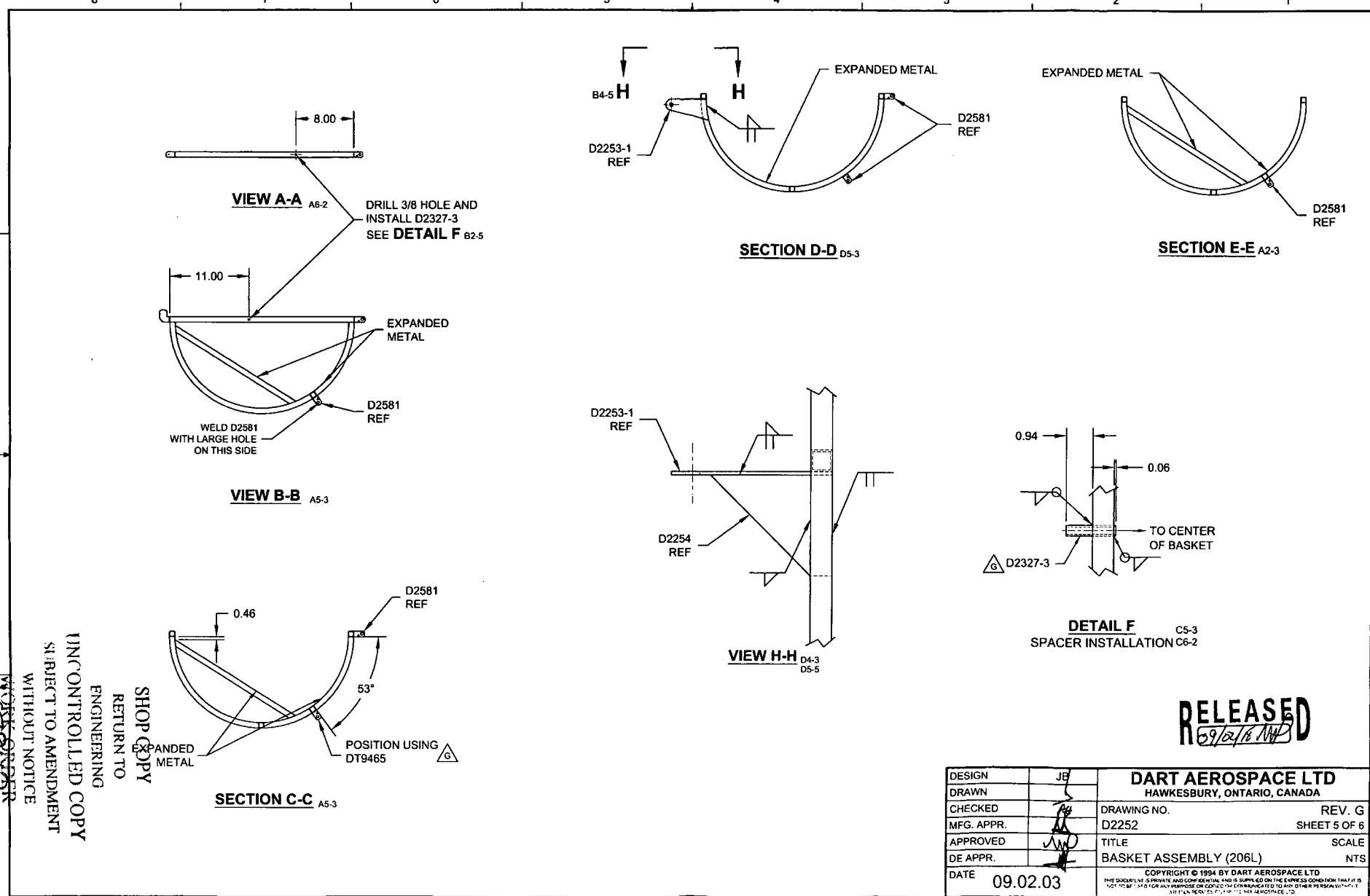
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BASE FRAME NOTES:

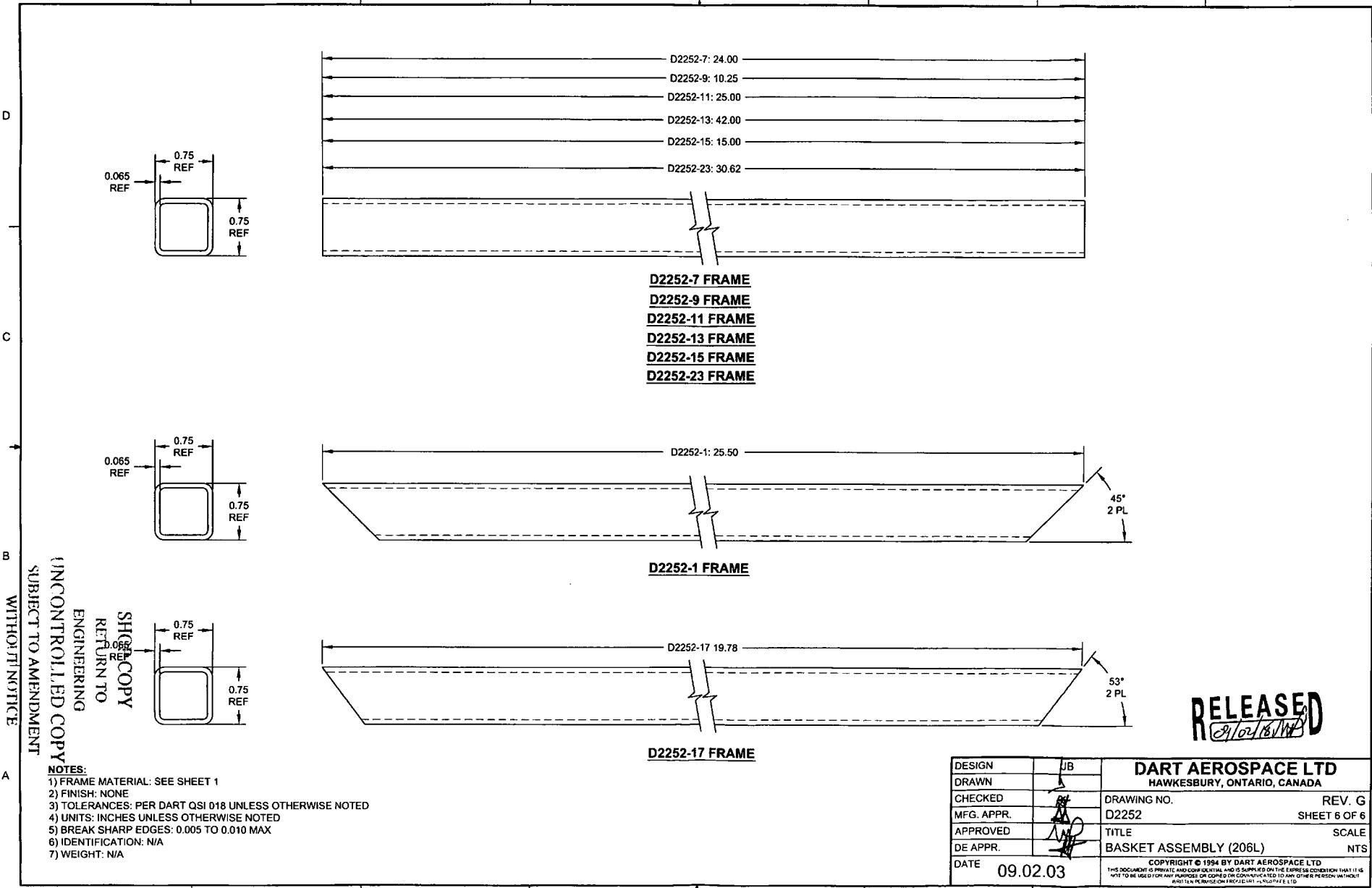
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: N/A
- 8) WELDING: PER DART QSI 004

8 7 6 5 4 3 2 1 0 1 2 3 4 5 6 7 8





8 7 6 5 4 3 2 1



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